

Date: Thursday, 10/18/2007 8:03:34 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	DOOR ASSEMBLY
Job Number	35213		
Estimate Number	11403		
P.O. Number	N/A	Part Number	D3296041
This Issue	10/18/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3296 REV A
First Issue	N/A	Project Number	N/A
Previous Run	33124	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By		Due Date	10/31/2007
Comment	Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM	Qty:	8 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D32961	Door Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Door Panel	
		Pick:	
		Qty Part Number Description Batch	
		1 D3296-1 Door Panel B 35232	
			FF 07-11-05 (8)
2.0	D32963	Door Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Door Panel	
		Pick:	
		Qty Part Number Description Batch	
		1 D3296-3 Door Panel B 35233x7 B 33126x1	
			FF 07-11-05 (8)
3.0	D31617	Hinge 14"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Hinge 14"	
		Batch: B 33190x5 / B 35506x3 *	
			FF 07-11-05 (8)
4.0	D31619	Hinge 17"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
		Hinge 17"	
		Batch: B 35229	
			FF 07-11-05 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 35213

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 200.0000 Each(s)

Rivet, Universal Head

Batch: M105125

FF 07-11-05

(8)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 07-11-06

(8)

7.0 QC5 INSPECT WORK TO CURRENT STEP



S 07/11/06 cont'd

Comment: INSPECT WORK TO CURRENT STEP



8.0 POWDER COATING POWDER COATING



M102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

YJ 07-01-07

X8

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



M-J 07/11/09

SK

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 D2137 Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Decal - No Step

B35606 X5 → ml

Pick:

Qty	Part Number	Description	Batch
1	D2137	Decal	B33184 (3) J8

11.0 D2419 Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Handle

Pick:

Qty	Part Number	Description	Batch
1	D2419	Handle	B33186 J8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: DOOR ASSEMBLY
Job Number: 35213			Part Number: D3296041
Job Number:			
Seq. #:	Machine Or Operation:		Description :
12.0	D24620040	Seal	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Seal			
Pick:			
Qty	Part Number	Description	Batch
1	D2462-0040	Seal	<u>B29456</u>
13.0	D24620053	Seal	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Seal			
Pick:			
Qty	Part Number	Description	Batch
1	D2462-0053	Seal	<u>B29456</u>
14.0	D24620245	Seal	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Seal			
Pick:			
Qty	Part Number	Description	Batch
1	D2462-0245	Seal	<u>B29456</u>
15.0	D27281	Dart Logo label small	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Dart Logo label small			
Pick:			
Qty	Part Number	Description	Batch
1	D2728-1	Decal	<u>B24215</u>
16.0	AN960JD6	Washer	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)			
Washer			
Pick:			
Qty	Part Number	Description	Batch
1	AN960JD6	Washer	<u>M6085</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:34 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 35213

Part Number: D3296041

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
1	MS20470AD4-6	Rivet	M105408

A

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

ml 07/11/15 *8

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STA#

AS 07/11/19 B(8)

21.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/19

Job Completion



W 07/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

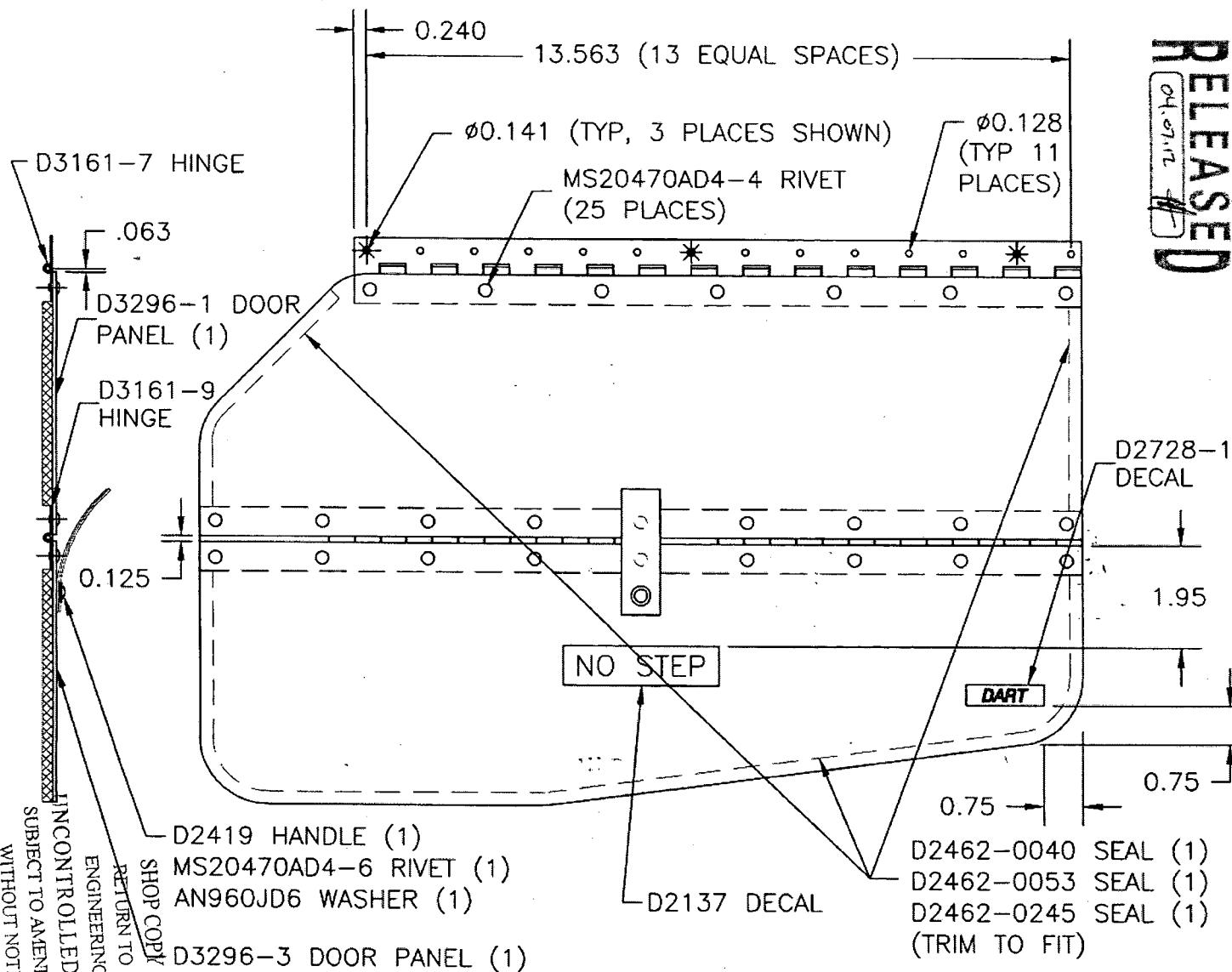
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		REV. A
4.06.28		D3296
04.06.28		1 OF 2
A	04.06.28	TITLE
		DOOR ASSEMBLY

RELEASED
04.07.12



WITHOUT NOTICE

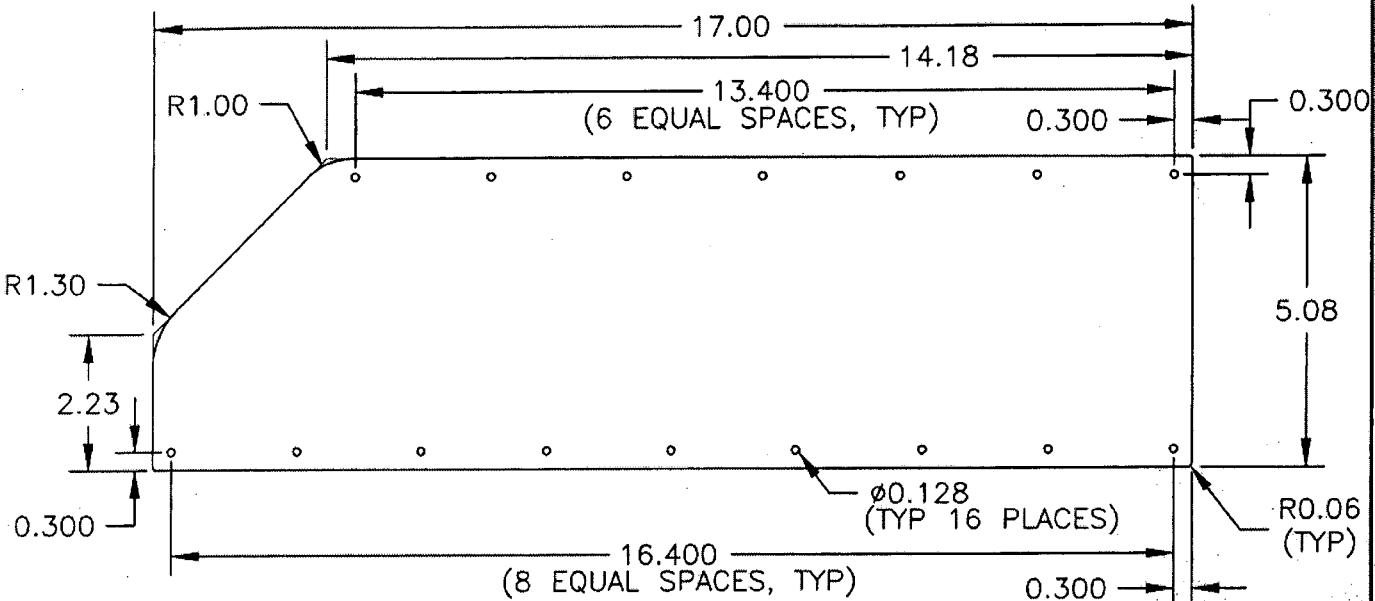
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

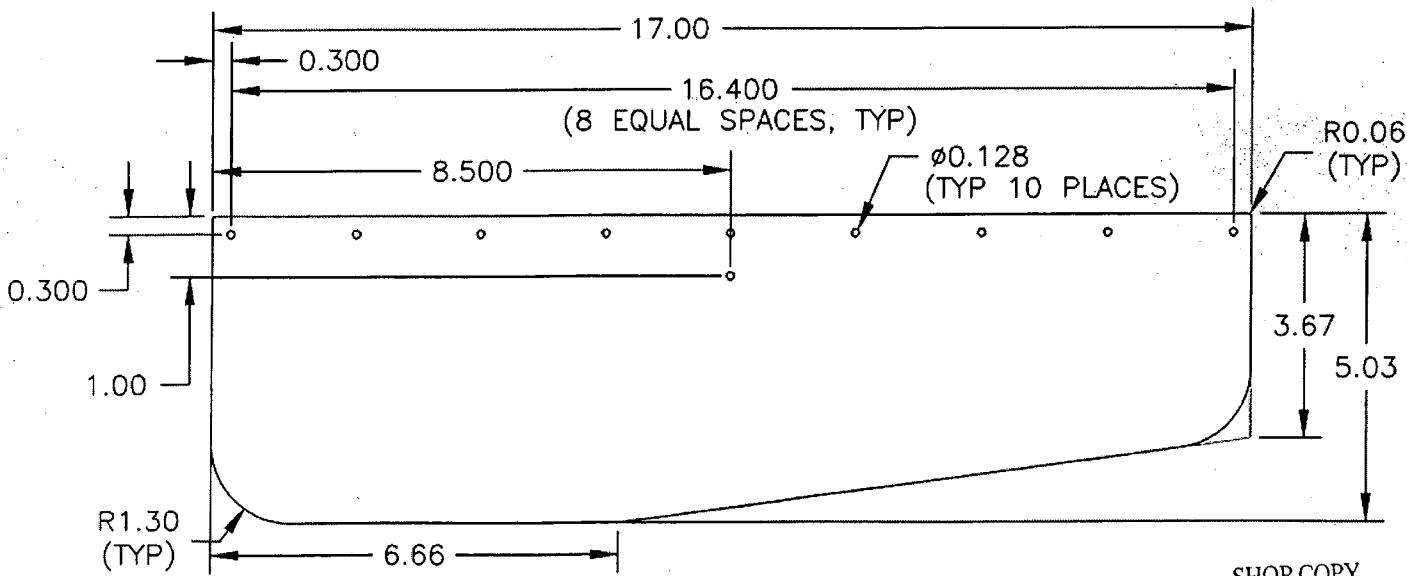


A circular stamp with the words "COPY ISSUED" printed around its perimeter.

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i> </i>	APPROVED <i> </i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28	TITLE DOOR ASSEMBLY		SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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